

Date: Tuesday, 13/05/2008 9:27:45 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HYDRAULIC CYLINDER
<b>Job Number</b> :	39219		
<b>Estimate Number</b> :	12750		
<b>P.O. Number</b> :		<b>Part Number</b> :	41232 200 007 001
<b>This Issue</b> :	13/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	41232-200-007 REV IR
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	30942	<b>Drawing Revision</b> :	IR
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08-5-13</u>	<b>Due Date</b> :	05/06/2008
<b>Comment</b> :	Est Rev:A New Issue 07-02-23 JLM	<b>Qty:</b>	6
		<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	7D 1 H	Clippard Brass Cylinder
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Spring (Step Actuator)

2.0	PG	PURCHASING
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**Comment:** PURCHASING  
 Issue P/O: 6357  
 Possible Supplier: Wainbee  
 Material release note is required

08/08/16

(6)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

AS 08/08/13

(6)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

08/08/14 (6)

5.0	SPRAY PAINTING	SPRAY PAINTING
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**Comment:** SPRAY PAINTING  
 Mask threaded ends and threaded holes.  
 1-Apply polyimide primer  
 Batch: M109278  
 2-Apply polyurathane coating gloss black  
 Batch: M109278

M1 08 09 16

(6)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 13/05/2008 9:27:45 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HYDRAULIC CYLINDER

Job Number: 39219

Part Number: 41232 200 007 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

Note: Paint Nut on threaded end and leave attached to assembly

6.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

08/09/19 (18)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Install Decal then

Identify and Stock

Location: \_\_\_\_\_

N/A - after assy 08/09/19 + 4 SYL v1/k  
08/09/19 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/19 H

Job Completion



MF 08-09-19

**Dart Aerospace Ltd**

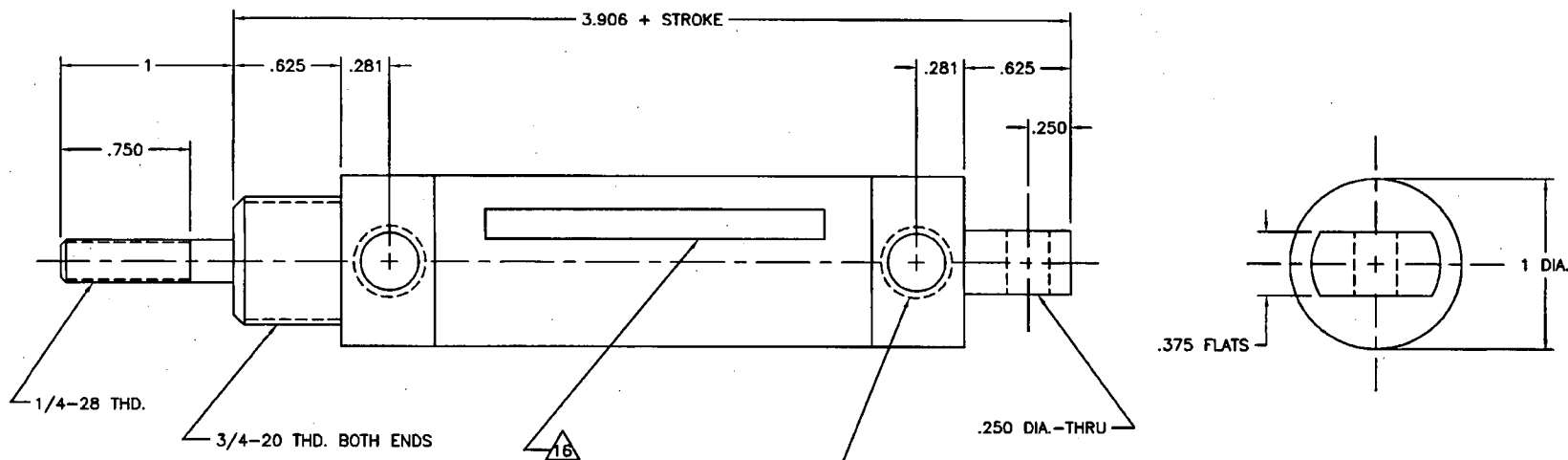
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



16. VIBRO ETCH ERA P/N 41232-200-007-001.

15. APPLY POLYURETHANE COATING, GLOSS BLACK (535U) IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4009.

14. APPLY POLYIMIDE PRIMER IN ACCORDANCE WITH ERA PROCESS SPECIFICATION 4004.

13. PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

NOTE - ALTER 7D1H ASSY IN ACCORDANCE WITH INSTRUCTIONS LISTED ABOVE.

12. SINTERED BRONZE ROD BUSHING.

11. ROD DIAMETER: 0.25 INCHES.

10. PORTS: 1/8 NPT.

9. POWER FACTOR: 0.6 SQ. IN.

8. STROKE: 1.000 INCH.

7. ACTION: DOUBLE ACTING.

6. MOUNT: UNIVERSAL MOUNT.

5. TEMPERATURE RANGE: 30° F TO 230° F.

4. 7D1H CONFIGURED WITH HYD. FLUID SEALS.

3. ROD: ROTATING.

2. BORE: 0.875 INCHES.

1. HEAVY DUTY BRASS CYLINDERS.

NOTES:

-001 BRASS CYLINDER

41232 200 008 001  
002

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39219

SHOP COPY  
RETURN TO

-001		BRASS CYLINDER 7D1H		CLIPPARD INSTRUMENT LABORATORY, INC., CINCINNATI, OH.	
PART NO.		NAME		STOCK SIZE	
NO. REQ'D PER ASSY		LIST OF MATERIAL		MATERIAL	
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED		TITLE	
THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. NO DISSEMINATION, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		DRAFTSMAN D. NELSON 3/14/03		HYDRAULIC CYLINDER (ALTERED ITEM DRAWING)	
2		CHECK D. MURPHY 3/14/03		SCALE NONE	
41232-000-001		STRESS		DWO. SIZE C	
DASH NO.		PROJ. ENGR.		REV. IR	
REV'D PER ASSY		HEAT TREAT		DWO. NO. 41232-200-007	
NEXT ASSEMBLY		FINISH		Era Aviation, Inc.	



WAINBEE LIMITED  
215 BOUL BRUNSWICK  
POINTE CLAIRE, PQ H9R 4R7  
Phone: 514-697-8810 Fax: 514-697-3070

## Packing List

CUSTOMER P/O NUMBER

:6357

RELEASE # 11199957-1

DATE 08/12/08 09:44:43

127404  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
613-632-3336

SHIP TO  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7

ORDER NUMBER 11199957	ORDER DATE 07/16/08	SHIP DATE 08/12/08	WRITTEN BY Martin Lessard	CONTACT C LAVOIE
CUSTOMER P/O NUMBER :6357				
JOB # F				
RELEASE #				

PRODUCT / DESCRIPTION	QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE / EXTENSION
7D-1-H CLIPPARD BRASS CYLINDER	6	EA	6	0	76.210 457.26

✓  
18/05/13

Wainbee's Standard Terms and Conditions Apply

Returned Goods Not Accepted Without Prior Authorization.

Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.